

# Work Order ID 66499

February 17, 2011 7:21:38 AM



Page 1

Item ID: D4035-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 2/17/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/23/11 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/02/17 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4035

A

100

Weld per dwg A/R S.S. rod Batch: 4114649 0.00



Large Fab

Memo

0.00

Large Fab

- 1- Cut D4035-3 as per dwg D4035
- 2- Drill holes using DT9563 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

SAD 11-02-17

(2)

11/02/17

110

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

11/02/17

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66499**

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Page 2

Item ID: D4035-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 2/17/11 Start Qty: 2.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Suloolis

FD

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Basket call

Memo

0.00

Packaging

11/02/22 (24)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/22

11-02-22 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February 17, 2011 7:21:37 AM

Page 1

Work Order ID: 66499

Parent Item: D4035-043

Parent Item Name: Lid Rib Assembly, Aft (350 Basket)



Start Date: 2/17/11

Required Date: 2/23/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA: new issue DD 09.11.25 verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4021-9 Manufactured No

100

Each

48.0000

2

4



Bushing

Location

Loc Qty

Loc Code

WA

48

56094

2

65363

5

65906

8

65924

33

M304TS0.750W.049

Purchased

No

100

f

258.6957

1.75

3.684211



304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT

223.9393209

113763

0

114323

8.15031894

114677

0.00001

114835

0.000039

116319

17.6181

116509

19.3317

116719

6.102353

116788

172.7368

MAT017

3.68448E-05

114298

3.6845E-05

WA

34.7563

114992

8.8798

115260

25.8765



11/02/17

41



3.684211  
SAD 11-02-17

3.6843

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

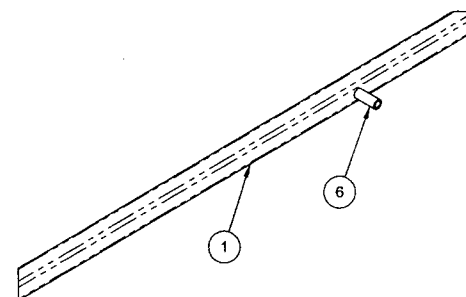
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

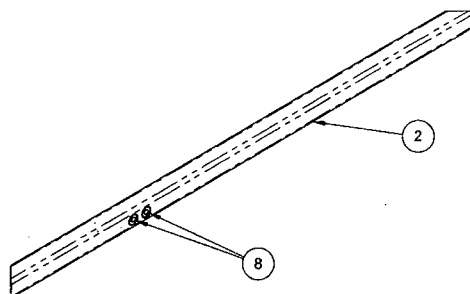
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

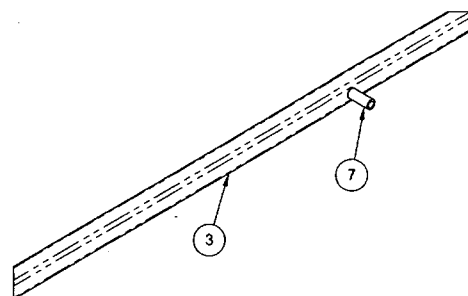
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



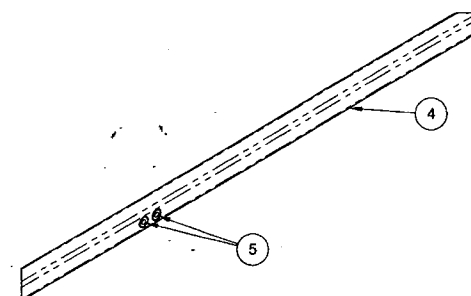
**D4035-041 BASKET LID RIB ASSY, FWD**



**D4035-043 BASKET LID RIB ASSY, AFT**



**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**



**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12

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WORK ORDER

NO. 66497  
CZ11102/17

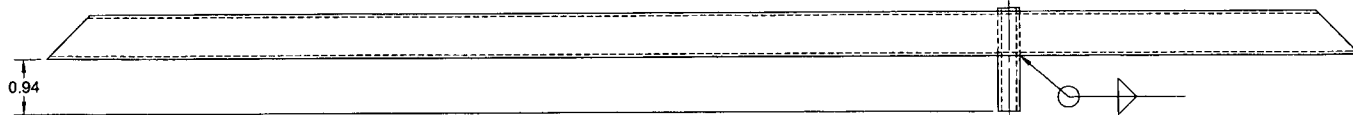
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.04		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4035</b>	REV. A SHEET 1 OF 5
TITLE <b>BASKET LID RIB ASSY</b>	SCALE NTS
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8 7 6 5 4 3 2 1

D

D



D4035-1  
RIB

D2327-3  
SPACER BUSHING

C

C

**D4035-041 BASKET LID RIB ASSY, FWD**

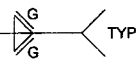
B

B



D4035-3  
RIB

D4021-9  
BUSHING  
2 PL



TYP

A

A

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.83 lbs
  - 8) WELDING: PER DART QSI 004

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MFG. APPR.	JPH	D4035	SHEET 2 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	BASKET LID RIB ASSY	NTS
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WDP

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

D

D

D4035-5  
RIB

C

C

D2953-175  
SPACER

0.94

**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**

D4035-7  
RIB

B

B

D4035-11  
BUSHING  
2 PL

G  
G  
TYP

**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12  
120




A

A

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

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MFG. APPR.		D4035	SHEET 3 OF 5
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

D

C

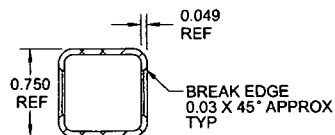
C

B

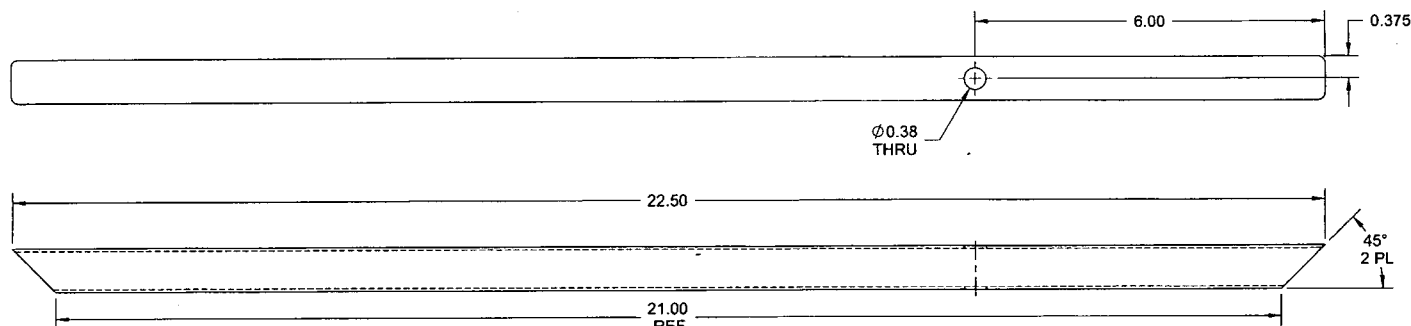
B

A

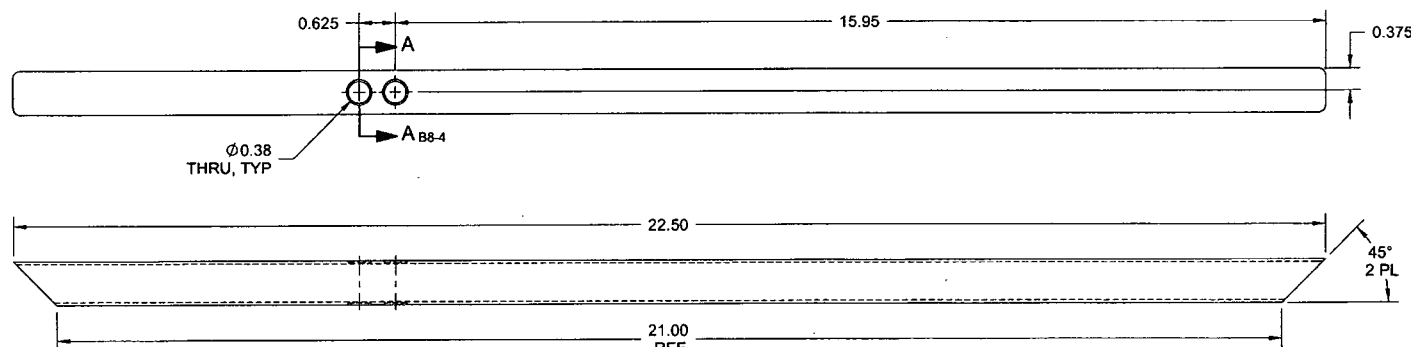
A



**SECTION A-A** B5-4



**D4035-1 RIB**



**D4035-3 RIB**

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AND

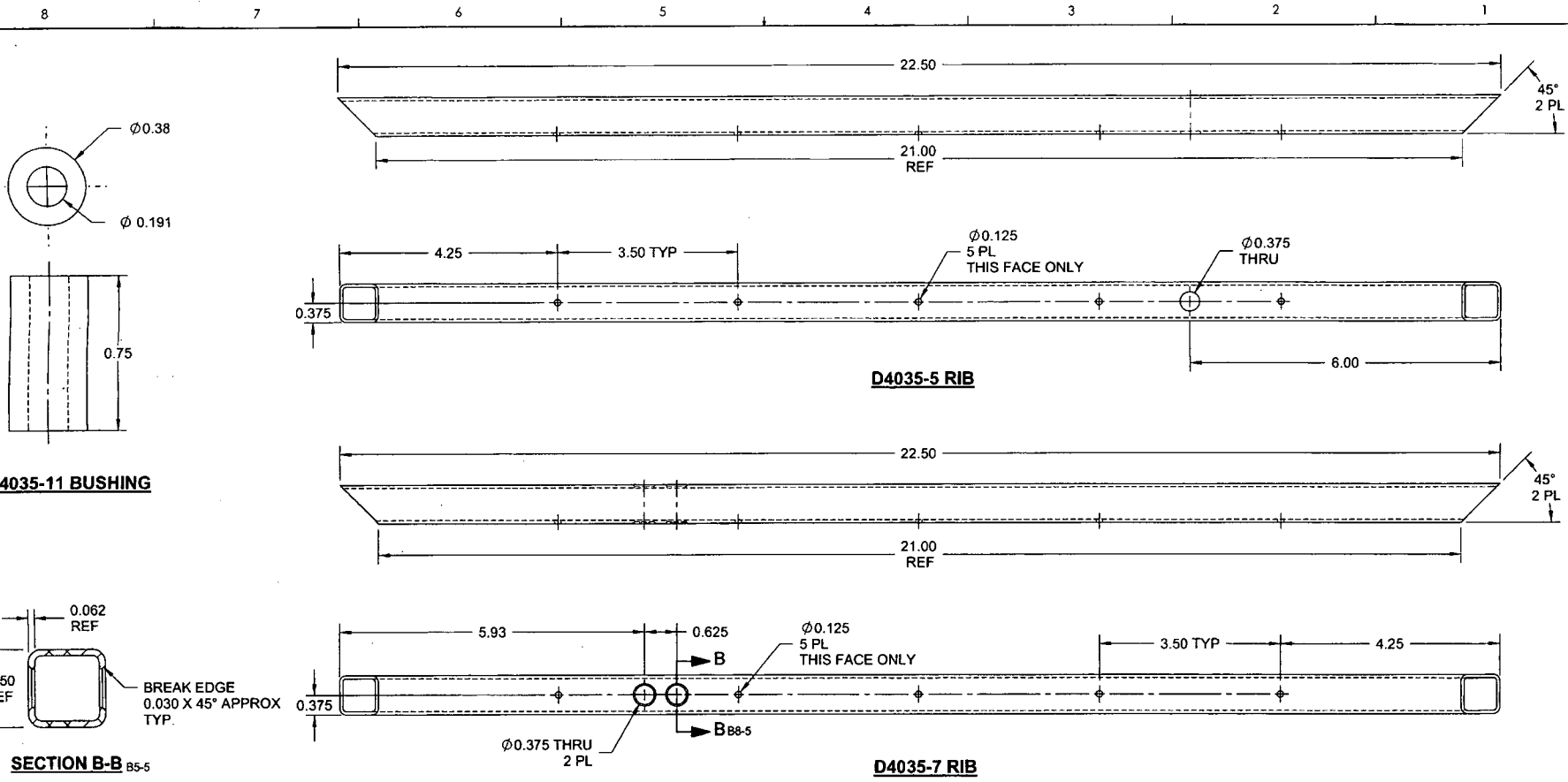
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
PER ASTM A554/A269 MILL FINISH  
REF DART SPEC. M304TS0.750W.049
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.80 lbs

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8 7 6 5 4 3 2 1



**D4035-11 BUSHING**

**D4035-5 RIB**

**D4035-7 RIB**

- NOTES:
- 1) MATERIAL: -5 & -7: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING  
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6TS0.750W.062  
-11: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6R
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: -5 & -7: 0.33 lbs; -11: 0.01 lbs

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